

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75099

75099

Page 2

October-17-11 1:24:40 PM

Item ID: D2939-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle LH In, 206

Start Date: 17/10/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 2:50 OVEN TEMPERATURE:
 FINISH TIME: 3:20

32001

3:20

ml 7480

6 X P M - 12/02/06

6 0

6 0 CF 12-2-6

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>6 12-26</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>428A</u> Memo	0.00 0.00							<u>12/20 5/16x</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/2/7</u>

12-02-7
(6)

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Picklist Print

October-17-11 1:24:44 PM

Page 1

Work Order ID: 75099

75099

Parent Item: D2939-1

D2939-1

Parent Item Name: Saddle LH In, 206

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	4.0000	1	6			
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D6101-001

Saddle Billet

**

H.A 12/02/02

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768

1

→ 78150

→ 73774

1.0

5.0

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DART AEROSPACE LTD	Work Order: 75099
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions						5 By	6 Date
				1	2	3	4				
A	0.100	0.140		0.127	0.127	0.126	0.127	0.127	0.127	0.127	0.127
B	0.100	0.140		0.127	0.128	0.127	0.127	0.127	0.127	0.127	0.128
C	0.100	0.140		0.116	0.116	0.116	0.116	0.116	0.116	0.116	0.116
D	0.210	0.230		0.225	0.225	0.225	0.225	0.225	0.225	0.225	0.225
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.260
L	0.312	0.317		0.314	0.314	0.314	0.314	0.314	0.314	0.314	0.314
M	0.235	0.240		0.237	0.237	0.237	0.237	0.237	0.237	0.237	0.237
N	0.100	0.140		0.125	0.125	0.125	0.125	0.125	0.125	0.125	0.125
O	0.540	0.560		0.550	0.550	0.550	0.550	0.550	0.550	0.550	0.550
P	0.490	0.510		0.500	0.500	0.500	0.500	0.500	0.500	0.500	0.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		0.255	0.255	0.255	0.255	0.255	0.255	0.255	0.255
T	0.100	0.180		0.135	0.135	0.135	0.135	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	0.316	0.316	0.316	0.316	0.316	0.316
X	1.250	1.270		1.261	1.261	1.261	1.261	1.261	1.261	1.261	1.261
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188	0.188	0.188	0.188
AA											
AB											
AC											
AD											
AE											
AF											
AG											
AH											
Accept/Reject											

Measured by: H.A
Date: 12/07/03

Audited by: [Signature]
Date: 12/02/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

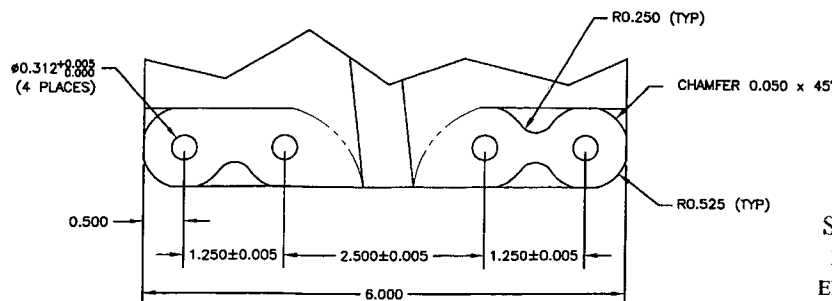
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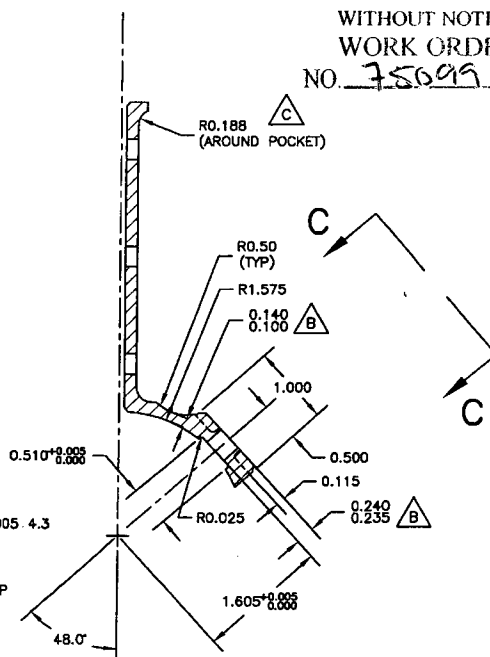
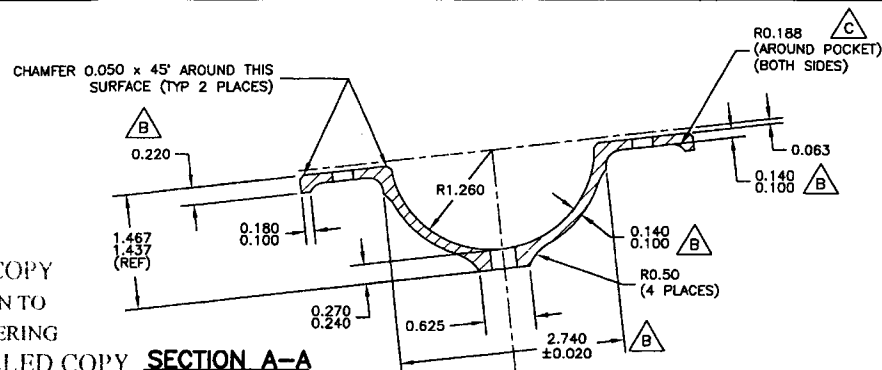
NOTE: Date & initial all entries



VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

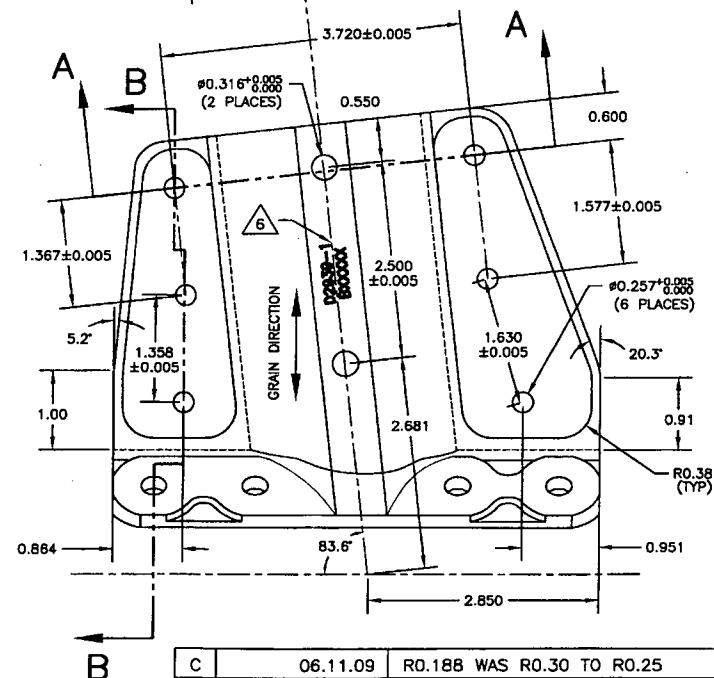
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY **SECTION A-A**
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 75099 M.C.J
11/10/17



SECTION B-B

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE USA, INC.

DESIGN	<u>PH</u>	DRAWN BY	<u>CB</u>	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	<u>PH</u>	APPROVED	<u>CB</u>	DRAWING NO. D2939
DATE	06.11.09	TITLE	SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE 2:3

07.02.12 PH

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